FRONT BOLT ACTION ASSAULT SHOTGUN

SPECIFICATIONS:

CATEGORY . . . . . IMPROVISED; NOTE: CAN BE MANUFACTURED COMMERCIALLY

CALIBRE . . . . . 410 TO 12 GAUGE; ADAPTABLE

CAPACITY . . . . . 8 TO 10 ROUNDS, .410 CAL.

OPERATION . . . . . SINGLE COLUMN MAGAZINE FEED, MANUAL BOLT ACTION-CAN BE MANUFACTURED FOR SEMI OR SELECTIVE FULL AUTOMATIC FIRE.

REMARKS: ***THIS SHOTGUN IS A REMARKABLE IMPROVEMENT OVER CONVENTIONAL BOLT ACTION SYSTEMS. POSITIONING ITS BOLT ACTION OPERA TION IN FRONT PERMITS FASTER OPERATION, SINCE THE HAND THAT OPERATES THE TRIGGER DOES NOT LEAVE ITS POSITION. BOLT OPERATION AND MAGAZINE LOADING ARE ACCOMPLISHED WITH THE LEFT HAND. THE STRAIGHT STOCK CONFIGURATION ELIMINATES EXCESSIVE MUZZLE JUMP AND ALLOWS FASTER RECOIL RECOVERY. THIS SYTEM IS ADAPTABLE TO HIGH POWERED CENTER FIRE AMMUNITION.***

TO LOAD:

Insert the loaded magazine in the receiver until the magazine catch snaps firmly. Magazine capacity will depend on the size and calibre of the weapon.

TO FIRE:

The bolt handle operates the same as in a conventional bolt action system. Tilt the handle 45 degrees upward and pull it all the way towards you. Push the handle back to feed a round into the chamber from the magazine. A spring operated firing pin will now engage the sear, ready to ignite the cartridge.

The trigger must be released after each shot. This releases the sear to engage with the firing pin lug.

SAFETY:

A safety mechanism is incorporated to block sear movement when applied. The safety lever is operated by the same (left) hand that operates the bolt mechanism and loading.

CONSTRUCTION DETAIL:

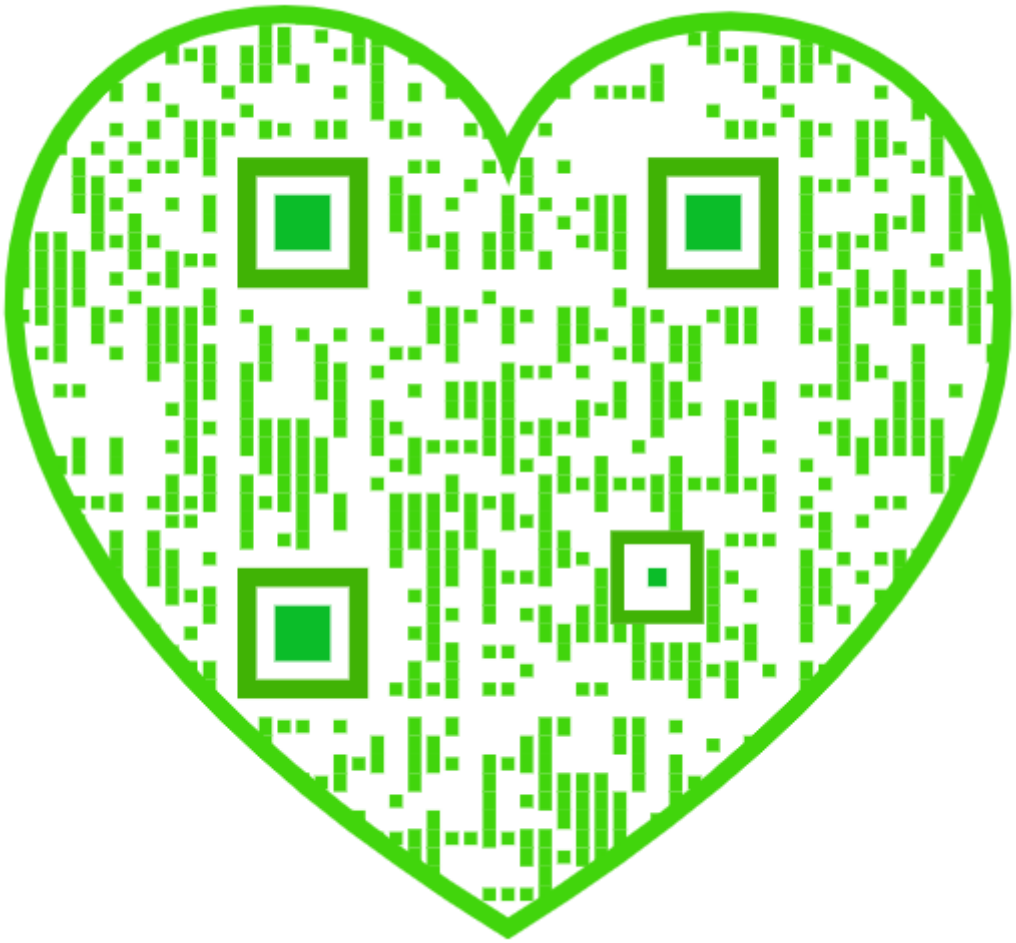
BARREL: Improvise the barrel (if no commercial barrel is available) from seamless tubing. An enforcement jacket should be employed to strengthen the barrel. Enforce the muzzle with steel sheet molded and formed as the front sight. Both the barrel enforcement jacket and muzzle front sight enforcement should be welded or brazed in place.

Another tube of smaller diameter containing the bolt extension where the bolt handle is housed should be brazed or welded on top of the barrel for solid mating.

BOLT: The bolt must be of good quality steel. It requires some simple machining or can be built by hand, using assorted files, drills, and patience. It should feed reliably when operated.

The bolt is connected to the bolt extension or carrier by means of a connecting block. The bolt is pinned solidly to this block, while the bolt extension or carrier rotates freely when the bolt handle is tilted to load and extract empties. The sole bolt lock is the notch on the bolt extension tube where the bolt handle rests in its downward position.

TRIGGER HOUSING FRAME: The trigger housing frame is a simple formed steel sheet 1/16 inch thick. Form it so that the magazine



can be inserted fully and easily when loaded.

TRIGGER MECHANISM: The entire trigger mechanism should be 3/8 inch thick, if possible. It will need spacers to fit properly inside the wide trigger housing.

GRIP: The grip is one piece construction made from plastic or wood stock. It is retained in place to the housing frame by a single screw mating with the cross bolt nut on the grip stock.

RECEIVER REAR COVER - BUTT PLATE: The receiver rear cover also acts as a butt plate, containing two steel plugs, which are brazed or welded in place. The plate is secured to the receiver by a pin connected to one of the plugs.

PARTS LIST

1. Front sight
2. Receiver cover plate lug - secures rear portion of triger housing (lug is brazed to plate)
3. Latch pin retaining plate
4. Latch pin retaining plate screw (hex type)
5. Cocking handle bolt tube plug
6. Plug retaining pin
7. Cocking handle retaining screw (headless)
8. Cocking handle
9. Trigger bar extension link (outside)
10. Cocking handle bolt
11. Cocking handle bolt tube - brazed to barrel jacket (can also be welded in place)
12. Rear sight
13. Safety lever retaining plate
14. Receiver pivot screw nut
15. Firing pin spring plug retaining pin
16. Pins connecting firing pin extension to base
17. Base of firing pin
18. Sear pin with spacers on both sides
19. Sear
20. Sear stop pin
21. Receiver cover plate
22. Front sight retaining pins
23. Pins connecting cocking handle bolt to bolt carrier securing bolt
24. Bolt carrier securing bolt
25. Base of front sight - brazed to barrel
26. Barrel - brazed to barrel
27. Barrel jacket (to support strength of barrel if commercial barrels are not accessible)
28. Receiver connecting lug - welded or brazed to jacket
29. Receiver / trigger housing connecting screw
30. Safety lever pin
31. Trigger guard rivet (2)
32. Trigger bar connecting pin
33. Trigger pin with spacers on both sides
34. Trigger
35. Trigger guard
36. Trigger plunger spring
37. Plunger spring
38. Grip screw
39. Steel washer for screw
40. Grip stock (one piece - wood)
41. Trigger bar (2 pr.)
42. Feed ramp retaining pins
43. Trigger bar / trigger bar extension connecting pins (riveted)
44. Feed ramp (insert - formed plate)
45. Firing pin
46. Firing pin spring
47. Magazine catch
48. Catch pin
49. Catch plunger
50. Magazine catch plunger assy. base pins - riveted
51. Base for plunger assembly (steel plate)
52. Magazine catch plunger spring
53. Trigger bar extension / sear connecting pin
54. Sear spring retaining bolt
55. Sear spring
56. Trigger housing frame - formed steel sheet

57. Latch lever pin
58. Magazine assembly - (improvised) depending on calibre & capacity required.
59. Steel washer
60. Cocking handle knob retaining pin
61. Cocking handle knob
62. Feed ramp pin plate
63. Screw (hex type) retaining ejector
64. Extractor spring (coil type)
65. Extractor

(For related photo, see page 51 *Improvised Modified Firearms Vol. 11,* Paladin Press.)

PARTS LIST

1. Front sight
2. Receiver cover plate lug - secures rear portion of trigger housing (lug is brazed to plate)
3. Latch pin retaining plate
4. Latch pin retaining plate screw (hex type)
5. Cocking handle bolt tube plug
6. Plug retaining pin
7. Cocking handle retaining screw (headless)
8. Cocking handle
9. Trigger bar extension link - positioned on both sides of receiver (outside)
10. Cocking handle bolt
11. Cocking handle bolt tube - brazed to barrel jacket (can also be welded in place)
12. Rear sight
13. Safety lever. retaining plate
14. Receiver pivot screw nut
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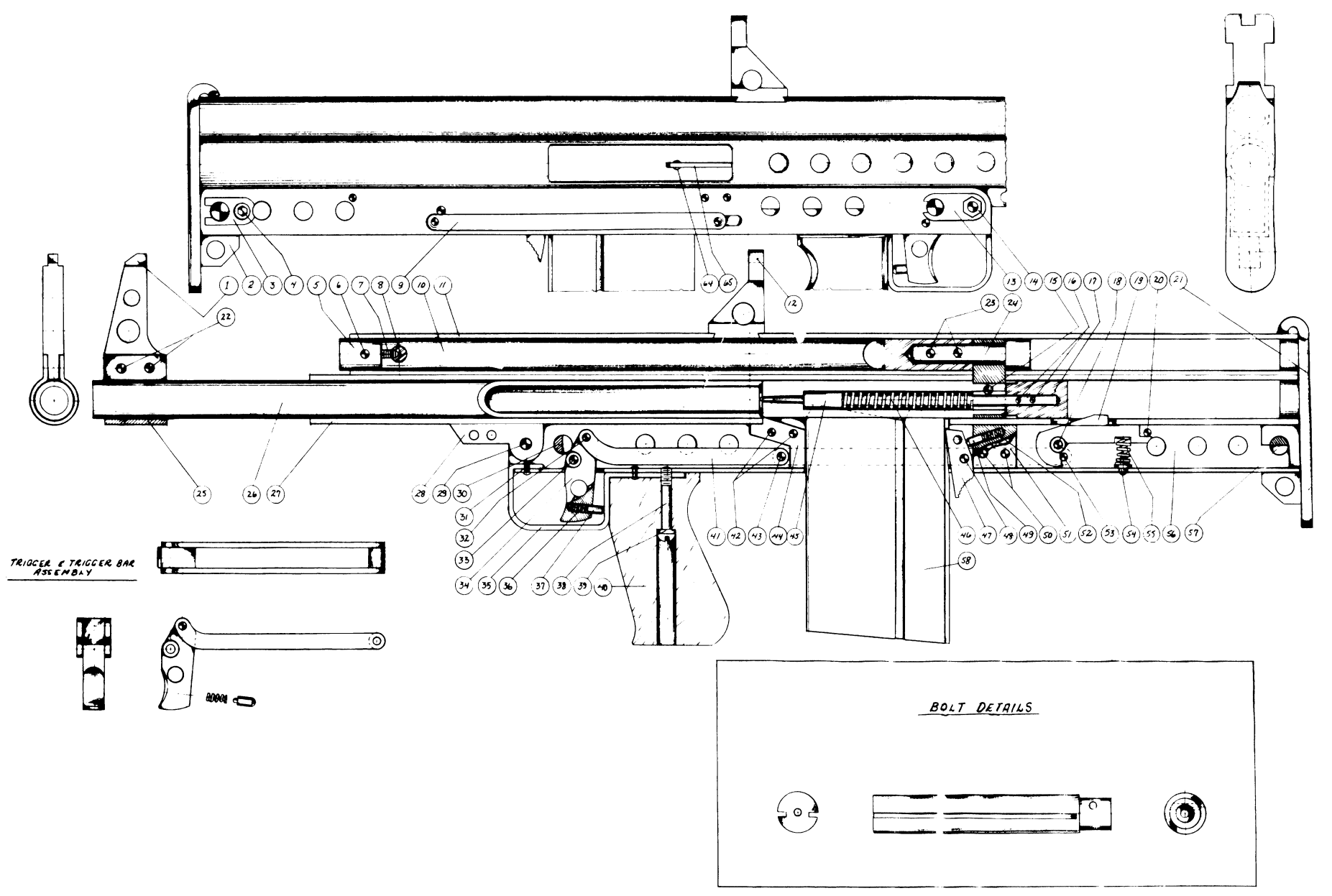

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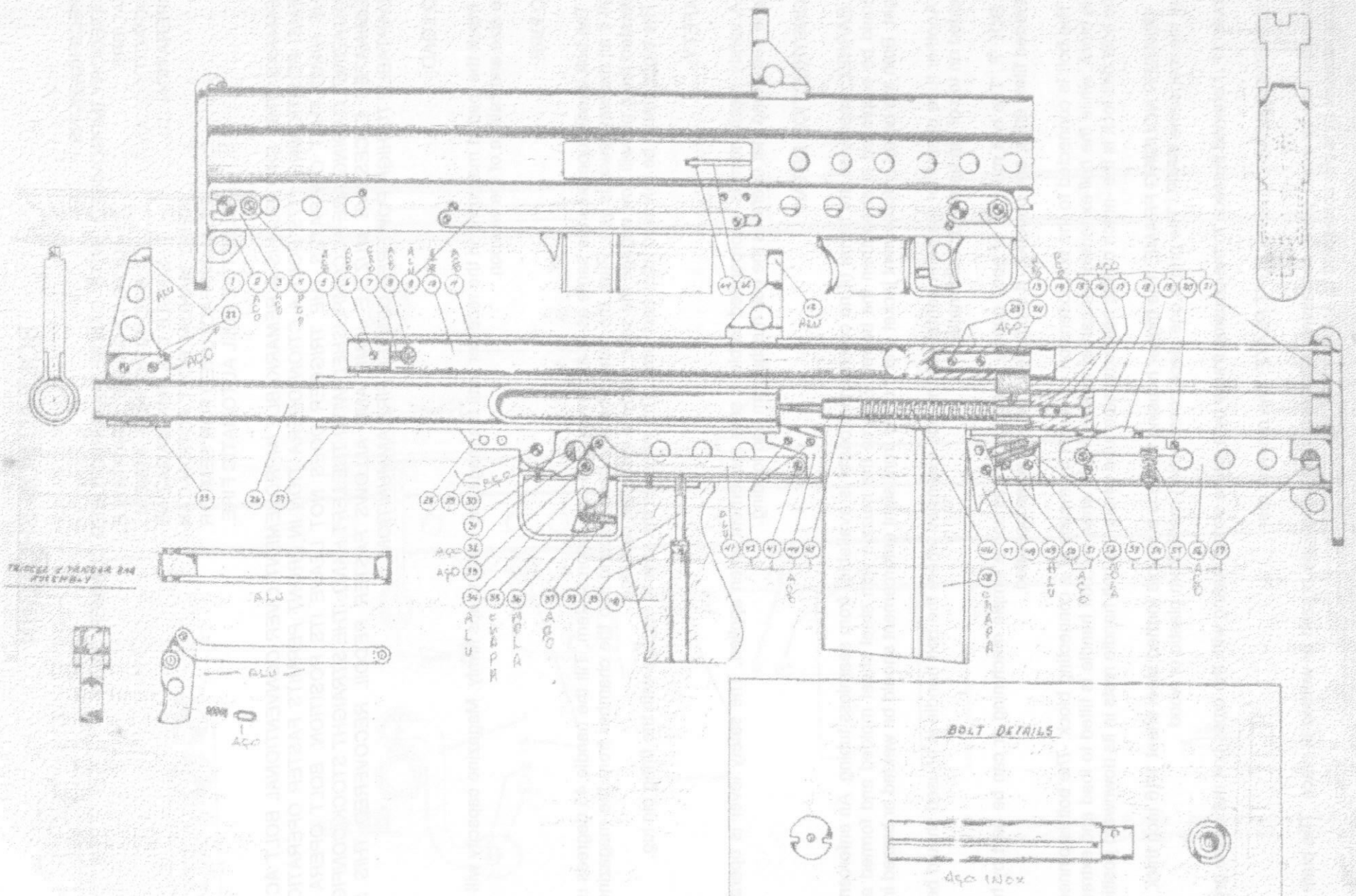
TRIGGER & TRIGGER BAR ASSEMBLY
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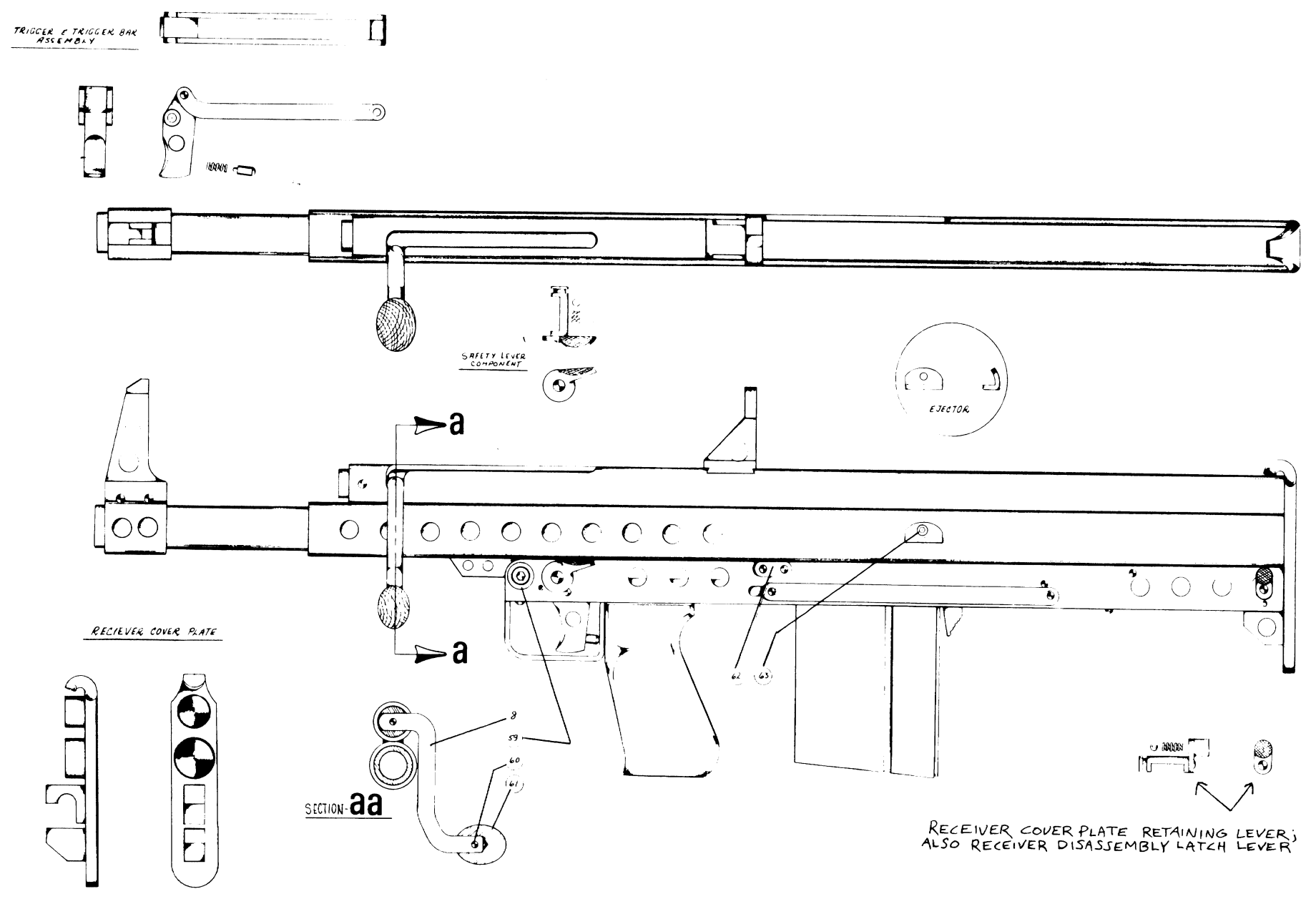
AÇO
BOLT DETAILS
AÇO INOX


TRIGGER & TRIGGER BAR ASSEMBLY
SAFETY LEVER COMPONENT
EJECTOR
a
a
RECIEVER COVER PLATE
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SECTION-aa
RECEIVER COVER PLATE RETAINING LEVER; ALSO RECEIVER DISASSEMBLY LATCH LEVER